

Work Order ID 150173

Wednesday, August 24, 2016 11:46:46 AM

150173

Page 1

Item ID: D117-762-011

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/6/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/16/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 24 2016** Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-762	E	DAS 6 9-89 AUG 25 2016					DAS 21 9-89	16-08-25	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.25							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-762-011	CHG003							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

B148514

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

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Page 2

Item ID: D117-762-011**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube with Standard Wearplates Fits LH or RH**Start Date:** 9/6/2016 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/16/2016 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					DAS 27 9-89			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-762-011 Location :FG081								
						SEP 14 2016			
140	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
140									
QC	Memo	0.02							
Quality Control									
									SEP 13 2016 SEP 13 2016 Jem 10/09/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
OTHER :																									

Picklist Print

Wednesday, August 24, 2016 11:46:49 AM

Page 1

Work Order ID: 150173

150173

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/6/2016

Required Date: 9/16/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.06.11New Issue EC
IPP Rev:B 08-02-22 change to revA DD verified by:ec
IPP Rev C 08.12.19 incorporated DSI9435 EC verified by:DD
IPP REV:D 13.11.14 IIN REV.C DD VERF:JLM IPP
REV:E 15.06.11 IIN REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D117-762-041		Manufactured	No			110	Each	0.0000	1	1			
D117-762-041									**				
Replacement Skidtube													
D3512-041		Manufactured	No			110	Each	12.0000	2	2			
D3512-041									**				
Wearplate													
Location ST610 142292 148668 Loc Qty 12 4 8 Loc Code													
AN6C51A		Purchased	No			110	Each	2.0000	2	2			
AN6C51A									**				
BOLT													
Location ST333 134511 Loc Qty 2 2 Loc Code													
D3864-1		Manufactured	No			110	Each	15.0000	4	4			
D3864-1									**				
Bushing													
Location ST055 138204 Loc Qty 15 15 Loc Code													

B148814 smB

PC

PC

PC

DAS
6
9-89

DAS
6
9-89

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 2

Work Order ID: 150173

150173

Parent Item: D117-762-011

D117-762-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/6/2016

Required Date: 9/16/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

110

Each

121.0000

2

2

MS21043-6

NUT

PC

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	20	
103693	20	
FP001	37	
m134365	1	
m135297	36	
ST302	64	
m134817	34	2
m135470	30	

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____		Work Order update only ☐																																															
Work Order: _____ Part No. _____ NCR No. _____		<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2" style="text-align: center;">DISPOSITION</th> <th colspan="4" style="text-align: center;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="text-align: right;">Rework</td><td>☐</td> <td style="text-align: right;">Skid-tube</td><td>☐</td> <td style="text-align: right;">Cross tube</td><td>☐</td> <td style="text-align: right;">Water Jet</td><td>☐</td> <td style="text-align: right;">Engineering</td><td>☐</td> </tr> <tr> <td style="text-align: right;">Scrap</td><td>☐</td> <td style="text-align: right;">Machining</td><td>☐</td> <td style="text-align: right;">Small Fab</td><td>☐</td> <td style="text-align: right;">Prod. Eng. Coord.</td><td>☐</td> <td style="text-align: right;">Quality</td><td>☐</td> </tr> <tr> <td style="text-align: right;">Use-as-is</td><td>☐</td> <td style="text-align: right;">Thermoforming</td><td>☐</td> <td style="text-align: right;">Finishing</td><td>☐</td> <td style="text-align: right;">Rec/Store/Packaging</td><td>☐</td> <td style="text-align: right;">Other</td><td>☐</td> </tr> <tr> <td style="text-align: right;">Suspected Unapproved</td><td>☐</td> <td style="text-align: right;">Large Fab</td><td>☐</td> <td style="text-align: right;">Composite</td><td>☐</td> <td style="text-align: right;">Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		
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150173

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Item ID: D117-762-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Stop ***NS2***Start Date: 9/6/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/16/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: **AUG 24 2016** Tooling: _____ Date: _____Run Start ***NR1***QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D117-762

E

DAS 6 **AUG 25 2016**

100

Document Control

9-89 0.00***100***

DC

DOCUMENT CONTROL

Memo

0.25

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D117-762-011 CHG003

DAS 21
9-89**AUG 25 2016**

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

5.0 PARTS LIST

DAS
28
9-89

5.1 D117-762-011 Skidtube Parts List

Item	Qty -011	Qty -041	Part Number	Description
	X		D117-762-011	SKIDTUBE INSTALLATION
	1	X	D117-762-041	REPLACEMENT SKIDTUBE
1		1	D3582-041	SKIDTUBE ASSEMBLY
2	2		**1121-51002	SKID SHOE
3	2		**1121-51102	CLAMPING RING
4	8		**LN9380M8X45	HEXAGON BOLT
5	8		**LN9023A8-1.4544.9	LOCKING WASHER
6	8		**LN9025-0815K	WASHER (OR LN9025-0815L)
10		1	*D2965	CAP
11		2	***AELS-1032-225	INSERT
12		2	*AN3C5A	BOLT
13		2	*NAS1149C0332R	WASHER (OR AN960C10L)
20A		1	*D3508-9	WEARPLATE
20B		1	*D3558-9	GASKET
21A		1	*D3508-3	WEARPLATE
21B		1	*D3558-3	GASKET
22A		1	*D3508-11	WEARPLATE
22B		1	*D3558-11	GASKET
23A		1	*D3508-13	WEARPLATE
23B		1	*D3558-13	GASKET
24		36	*AELS-1032-130	INSERT
25	8	28	*AN3C4A	BOLT
26	8	28	*NAS1149C0332R	WASHER (OR AN960C10L)
27	2		D3512-041	WEARPLATE
30		2	*AELS-1032-130	INSERT
31		2	*AN3C4A	BOLT
32		2	*NAS1149C0332R	WASHER (OR AN960C10L)
50	2		AN6C51A	BOLT
51	4		D3864-1	BUSHING
52	2		MS21043-6	NUT

* PART IS INCLUDED WITH D3582-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE